

Date: Thursday, 5/4/2006 1:09:26 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DUCT  
 Job Number : 27017  
 Estimate Number : 12315  
 P.O. Number : NIA Part Number : D34731  
 This Issue : 5/4/2006 S.O. No. : NIA Drawing Number : D3473 REV A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : NIA Type : PURCHASED PARTS Drawing Revision : A  
 Previous Run : 26117 Material : NIA  
 Due Date : 5/28/2006 Qty: 6 Um: Each  
 Written By : *See 1st comment below*  
 Checked & Approved By : *06.05.05*  
 Comment : Est Rev:A New Issue 06-03-02 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S26GA 304/316 0.018 SHEET



Comment: Qty.: 0.6305 sf(s)/Unit Total : 3.7832 sf(s)

304/316 0.018 SHEET

Batch: *M101000*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

Cut as per Dwg D3473

Dwg Rev: *A6*

Prog Rev: *A*

*SAD 06.05.19* (6)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*M11 06 05 19* (6)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*06.05.23* (6)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

2-Roll as per Dwg D3473


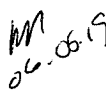
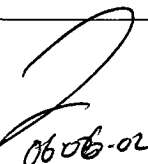
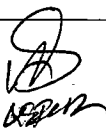

3-Form Small Flange as per Dwg D3473 using DT8861 Base & Dt8847B Male Die


*SB 06/06/03* (5)

*SB 06/06/03* (5)

*SB 06/06/03* (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
060602	4	1 part went missing. from water set shelf to inspection shelf. P&SS me off.		Count now at 5. Parts to be verified for Qty, and taped together.	 06.06.02	 0606-02	 0606-02	 0606-02

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 0606/02

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 5/4/2006 1:09:26 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUCT

Job Number: 27017

Part Number: D34731

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Form Large Flange as per Dwg D3473 Using DT8862

SB 06/06/03

5-Spot Weld as per Dwg 3473

SB 06/06/03

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 356

06/06/03

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/03

Job Completion



W 06/06/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

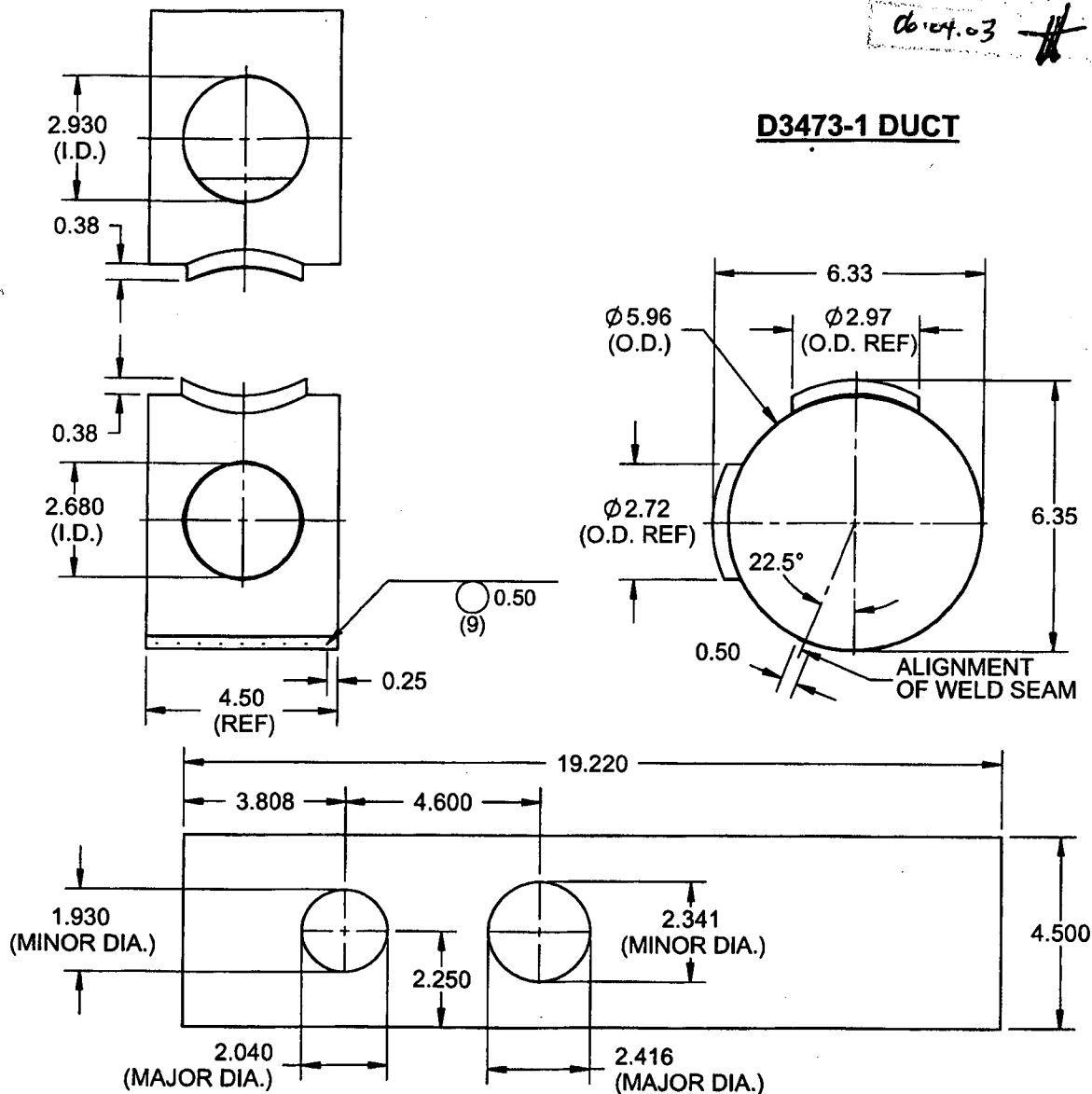
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



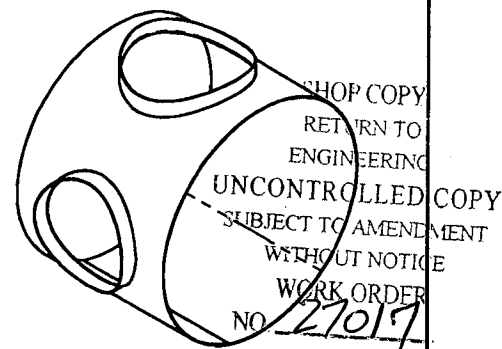
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3473</b>	REV. A SHEET 3 OF 7
DATE <b>06.02.07</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:4



### **D3473-1F DUCT FLAT PATTERN**

#### **NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)  
2B FINISH 26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010



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DART AEROSPACE LTD		Work Order:	27017
Description: DUCT		Part Number:	D39731
Inspection Dwg: 3473 Rev: B		Page 1 of 1	

## FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

[illegible]

Measured by:	SAN/KE	Audited by:	[Signature]	Prototype Approval:	N/A
Date:	06:05:18	Date:	06.05.23	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	